

Date: Tuesday, 3/20/2007 1:51:38 PM  
 User: Kim Johnston

## Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	FWD X-TUBE	
Job Number	31366		Part Number	D2889	
Estimate Number	10006		Drawing Number	D2889 REV B	
P.O. Number	N/A		Project Number	N/A	
This Issue	3/20/2007 S.O. No. N/A		Drawing Revision	B	
Prsht Rev.	NC		Material	N/A	
First Issue	N/A		Due Date	4/10/2007 Qty: 1 Um: Each	
Previous Run	31365				
Written By					
Checked & Approved By	9/07/03.20				
Comment	Est Rev:A New Issue 05-10-25 JLM				

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D6005180	Crosstube material
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Crosstube material Pick: Qty Part number Description Batch 1 D2889 Fwd Crosstube 23963 EL 7-5-17
2.0	BENDING	BENDING MACHINE
		Comment: LANDING GEAR RESOURCE 1 1-Bend D2889 as per Dwg D2889 and Folio FT001
		7-5-17
3.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
		Comment: LANDING GEAR RESOURCE 1 1-Deburr and Polish
		N/A
4.0	QC6	DIMENSIONAL CHECK
		Comment: DIMENSIONAL CHECK J07-05-22 ①
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
		Comment: HAND FINISHING RESOURCE #1 Acid etch and alodine as per QSI 005 4.1 Inside and outside of tube
		N/A

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 07/05/23  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 3/20/2007 1:51:38 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD X-TUBE

Job Number: 31366

Part Number: D2889

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



NIA J



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: W10 31971

J 20705-22 (v)

8.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

E 207105/23 (1)

Job Completion:



U 07-05-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

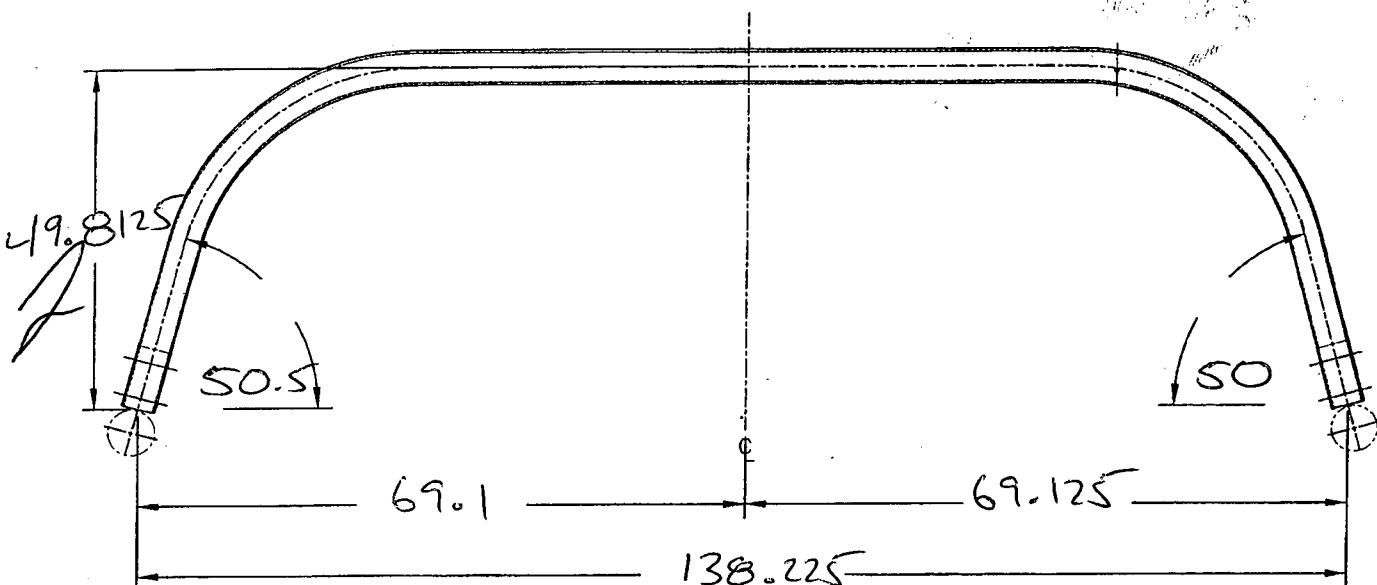
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	31366
Description: Crosstube Fwd	Part Number:	D2889
Inspection Dwg: D2889	Rev: B	Page 1 of 1

Required Dimension	Min	Max
Height	49.875	50.125
1/2 Span	69.275	69.525
Angle	49	52
Total Span	138.55	139.05



Comments
Tube is per D2889-596-105 B31971. Dims for -105 are perfect.

QC15 Inspection	<i>Jas1042</i>
Date	<i>0705-22</i>

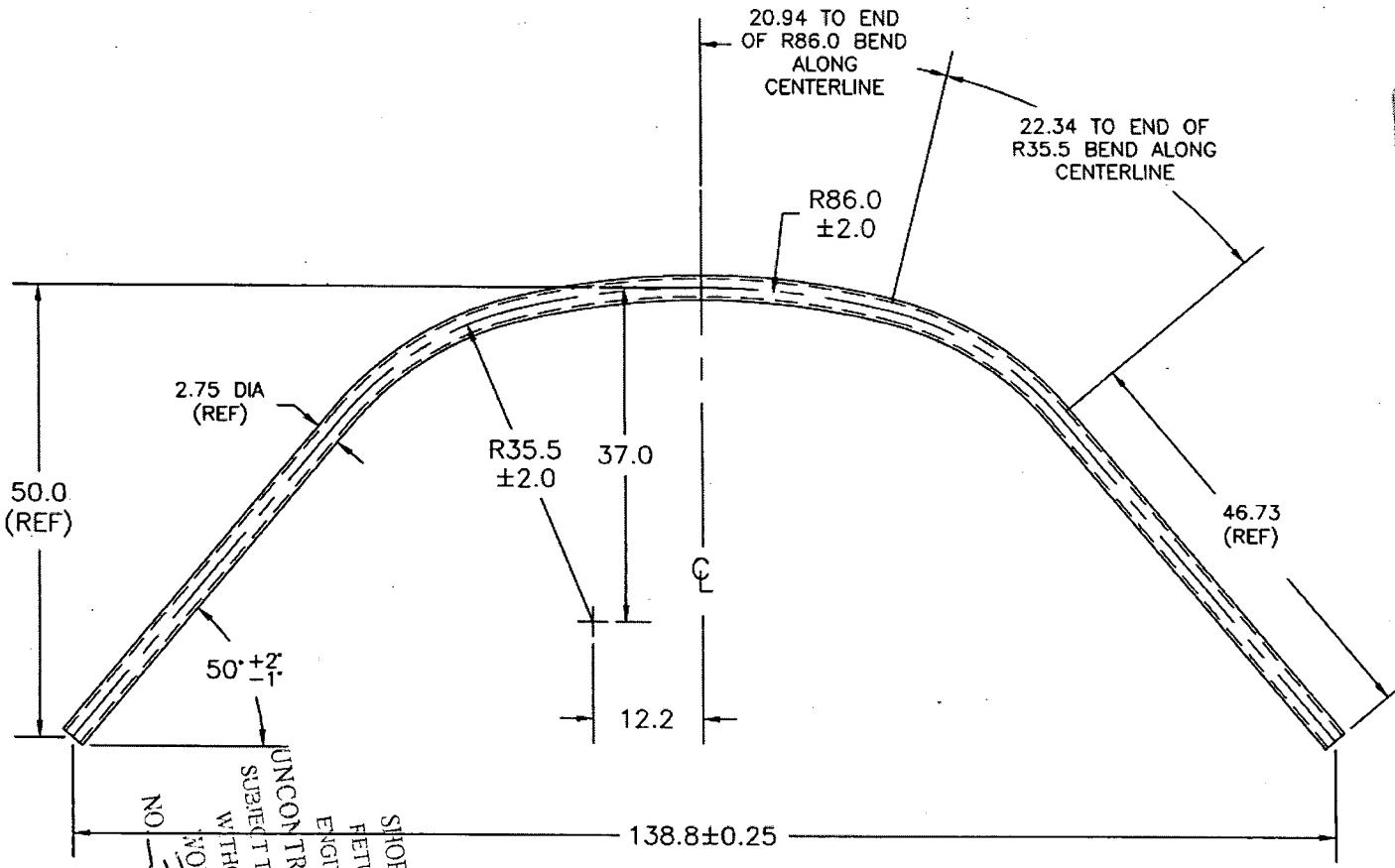
Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM <i>[initials]</i>	<i>[Signature]</i>

**DART**

02/10/28  
DRAFT

**RELEASED**

DESIGN	DRAWN BY	DART AEROSPACE LTD
	CP	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	REV. B
		DRAWING NO.
		D2889
DATE		SHEET 1 OF 1
02.10.18		
A	99.05.21	TITLE
B	02.10.18	FWD CROSSTUBE
		SCALE
		1:20



NOTES

- 1) MATERIAL: MANUFACTURE FROM D6005-180 ( $\phi 2.75$  OD x 0.375 WALL)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) BEND PROGRESSIVELY WITH MINIMUM OF 3 PASSES
- 6) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO 3136

